

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	1/4 TURN FASTNER RAIL (BLACK)
Job Number	:	34968			
Estimate Number	:	10096			
P.O. Number	:	N/A	Part Number	:	D103858B
This Issue	:	10/2/2007	S.O. No.	:	N/A
Prsht Rev.	:	NC	Drawing Number	:	D1038
First Issue	:	N/A	Project Number	:	N/A
Previous Run	:	34944	Type	:	MACHINED PARTS
			Drawing Revision	:	B
Written By	:	[Signature]	Material	:	N/A
Checked & Approved By	:	[Signature] 07.10.02	Due Date	:	11/5/2007
Comment	:	Est: E 03.05.02 Reformat; Added label KJ/RF			
		Est Rev:F 06-08-16 Updated Packaging Procedures JLM			

Qty: 60 Um: Each

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Create white labels and bag them

2.0 D2023 Extrusion, Fastener Rail

Comment: Qty.: 1.9030 f(s)/Unit Total : 95.1500 f(s)
Extrusion, Fastener Rail 83190

3.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine as per Folio and Dwg D1038-58

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0 QC8 SECOND CHECK

Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 1:45:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 34968

Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

Boyle 12/14 (60) counted

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Boyle 12/14 (x60)

9.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: 5290
Black Anodize as per Dwg D1038

Boyle 12/14 (60)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage

Boyle 1/1/04 (60)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

Boyle 08/01/07 (x60)

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389
Batch: M104298

2-Grind wire flush and deburr

3-Clean

Boyle 08/01/08 (x59) P10

13.0

QC5

INSPECT WORK TO CURRENT STEP




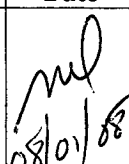

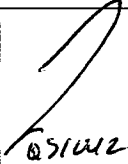
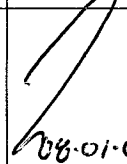
Comment: INSPECT WORK TO CURRENT STEP

Boyle 08/01/08 (x59)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-01-08	12.0	1 part found to be unsupplied, and does not fit into the jig.	 Q51412	Scraped destroy, no replace. #	 08/01/08	 08-01-08	 Q51412	 08-01-08

NOTE: Date & initial all entries

Date: Tuesday, 10/2/2007 1:45:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 34968

Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: 3 FG 14

AS 08/01/09

(59)

(60)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/01/11

Job Completion



W 08-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

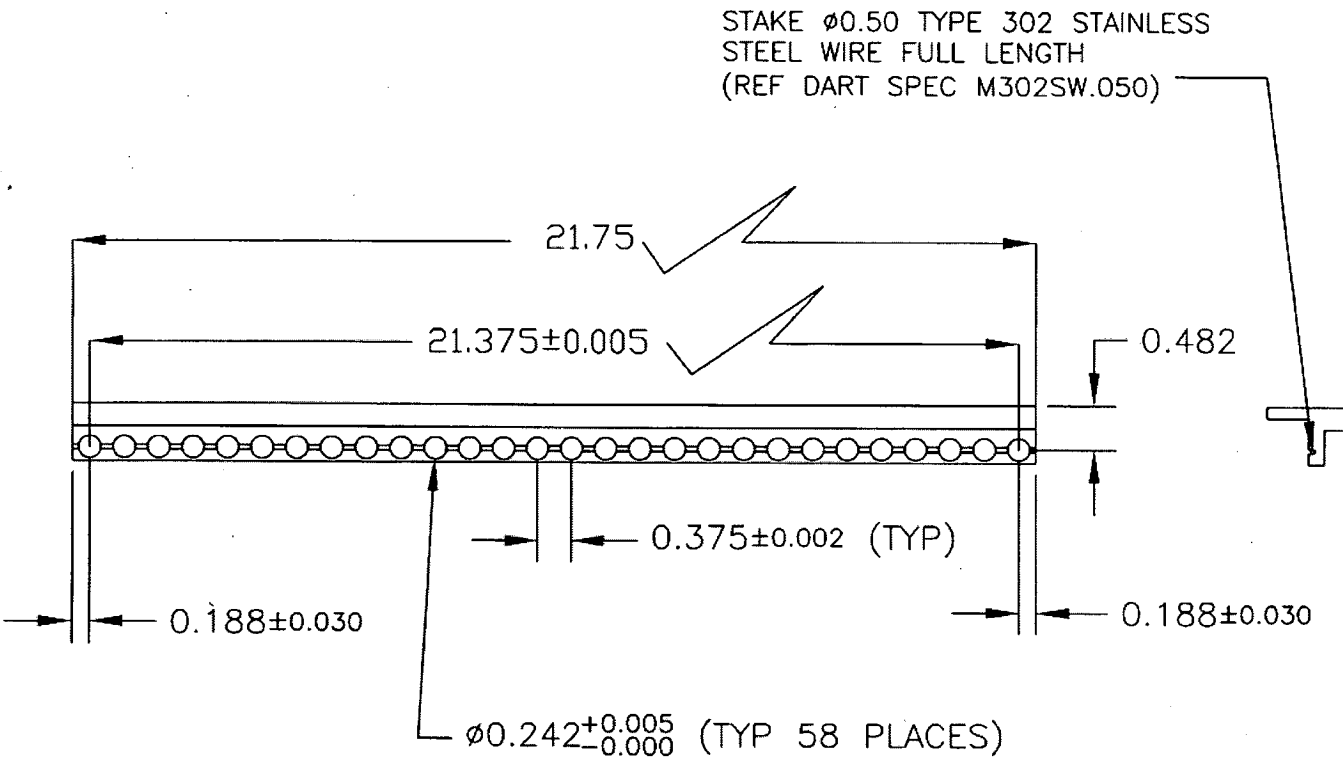
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**

05.03.31

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	DRAWING NO.	SHEET 1 OF 1	SCALE
05.02.02	D1038	1/4 TURN FASTENER RAIL	NTS
	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

**D1038-58 1/4 TURN FASTENER RAIL**

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO 34968

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TNM**ANODISATION et PEINTURE TNM INC.****C. OF C**

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

61066

21-Dec-2007

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE**CERTIFICAT DE CONFORMITE****PURCHASE ORDER/****NO. DE COMMANDE:****00005290**

5222



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	50	50	D1C3858B B34944	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
2	60	60	D1C3859B B34968	BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	15	15	D32993 B35139	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
4	13	13	D32991 B35138	BLUE ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager

